

84803

Page 1

Accept

N900040100

Setup Start *NS1*

Stop *NS2*

Start Date: 23/05/2012 **Start Qty:** 20.00

20

Cust Item ID:

Required Date: 06/06/2012 **Req'd Qty:** 20.00

20

Customer:

Reference:

Approvals: Process Plan: MLJ Date: 12/05/23

Tooling:

Date:

Run Start *NR1*

QC: _____ Date: _____ SPC (Y/N): _____

SPC (Y/N):

Date:

Stop *NR2*

[illegible]

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 84803

84803

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May-23-12 11:31:43 AM

Item ID: D2432

Accept

N900040100

Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: 206 (24") Bearpaw

Start Date: 23/05/2012 Start Qty: 20.00

20

Cust Item ID:

Required Date: 06/06/2012 Req'd Qty: 20.00

20

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start ***NR1***

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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150 QC8- Inspect parts - second check

0.00

150

QC

Memo

0.00

Quality Control

151 Identify as per dwg & Stock Location: _____ 0.00

151

Packaging

Memo

0.00

Packaging

190 QC21- Final Inspection - Work Order Release 0.00

190

QC

Memo

0.00

Quality Control

mf 12/07/03

20

CF 12/7/09

CF 12/7/09

MF 12-07-04

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NOTE: Date & initial all entries

Picklist Print

May-23-12 11:31:46 AM

Page 1

Work Order ID: 84803

84803

Parent Item: D2432

D2432

Parent Item Name: 206 (24") Bearpaw

Start Date: 23/05/2012

Required Date: 06/06/2012

Start Qty: 20.00

Required Qty: 20.00

Comments:

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
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MUHMWB10

Purchased

No

120

sf

53.2100

3.7

74

82.

MUHMWB10

UHMW 1" Black

**

B12-6-2

Location

Loc Qty

Loc Code

MAT018

30.1

120972

3

121346

27.1

MAT019

1.5

118814

1.5

ST052

21.60999474

121277

12.8

121278

8.80999474

121851

121851

20

W/O:		WORK ORDER CHANGES					
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DART AEROSPACE LTD		Work Order:	84803
Description: Bearpaw		Part Number:	D2432
Inspection Dwg: D2432	Rev: F3	Page 1 of 1	

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Inspection Sheet Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
A 0.063 x 45°	+0.030/-0.010	.064 x 45°	✓		SLO8	Vern
B 5.500	+/-0.030	5.502	✓			
C 0.200	+/-0.030	.199	✓			
D 0.25 x 45°	+/-0.030	.250 x 45°	✓			
E R0.250	+/-0.030	R.250	✓			
F 0.250	+/-0.010	.253	✓			
G 0.625	+/-0.030	.630	✓			
H 0.375	+/-0.010	.380				
I 0.950	+0.030/0.010	.967	✓			
J 19.000	+/-0.030	19.005	✓		Tape	
K 3.14	+/-0.030	3.125	✓		SLO8	Vern
L 3.28	+/-0.030	3.310	✓			
M Ø0.260	+0.005/-0.000	Ø.260	✓			
N Ø0.93	+/-0.030	Ø.927	✓			
O 0.30	+0.030/-0.000	.308	✓			
P 23.750	+/-0.030	23.745	✓		Tape	
Q 7.375	+/-0.030	7.375	✓		SLO8	Vern
R 4.250	+/-0.010	4.251	✓			
S 2.000	+/-0.030	1.9955	✓			
T 9.000	+/-0.010	9.000	✓			
U 9.000	+/-0.010	9.000	✓			
V 0.375	+/-0.010	.385	✓			

Measured by:	JS	Audited by:	am	Prototype Approval:	N/A
Date:	12/06/30	Date:	12/07/03	Date:	

Rev	Date	Change	Revised by	Approved
A	04.01.09	New Issue	KJ/RF	TF

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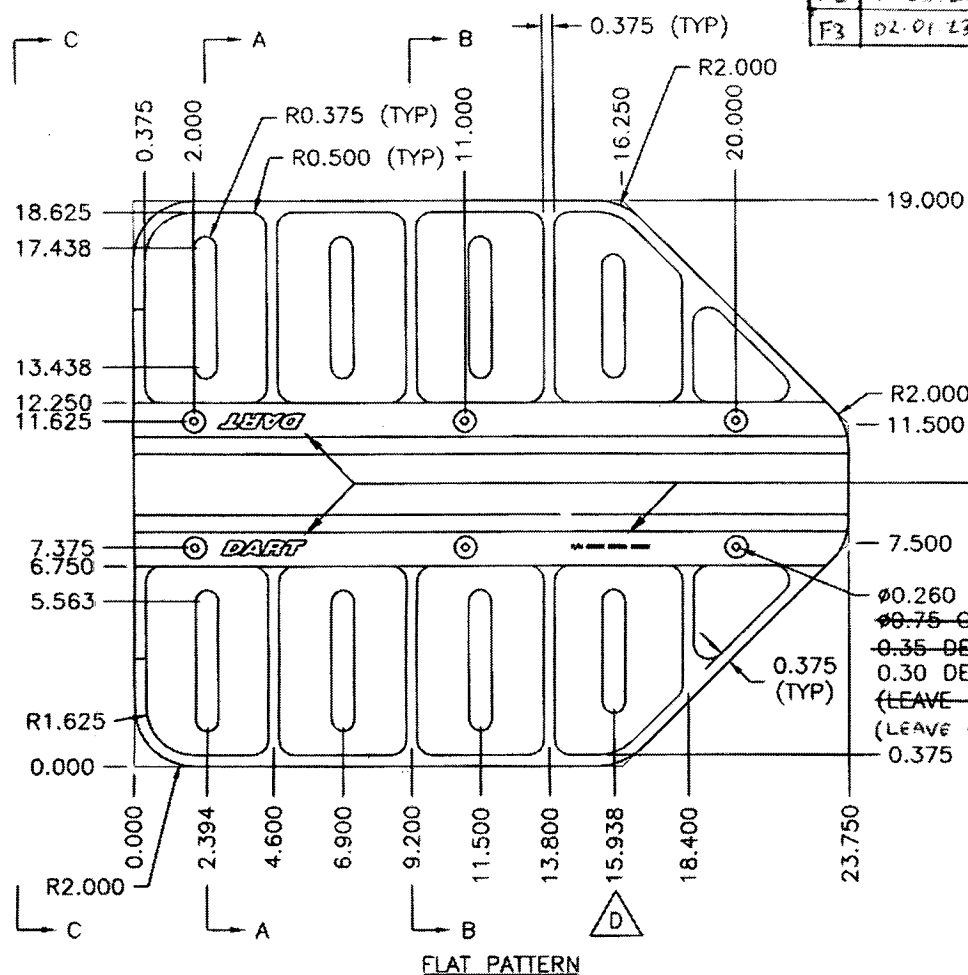
W. T. NOTICE
W. O. ORDER
NO. 2480

12/05/22




100-443886-100

98.06.17 KES

F1	99.03.00	ADD DEC 9143
F2	01.03.28	0.073 WAS 0.075 RF
F3	02.01.23	CLARIFY CORE DIMS RF RF



ENGRAVE LOGO TO MAX
DEPTH OF 0.012. ENGRAVE
PART AND BATCH NUMBERS
TO MAX DEPTH OF 0.010.
(TYPICAL LOCATION AS
ILLUSTRATED)

~~Ø0.260 (TYP)~~ 
~~Ø0.75 C'BORE Ø 0.93 C'BORE~~
~~0.35 DEEP FROM TOP (MIN.)~~
 0.30 DEEP FROM BOTTOM
~~(LEAVE 0.300 MIN.)~~ 
~~(LEAVE 0.650 MIN.)~~
 - 0.375 

EFFECTIVE DEOS

9143

D2432F: FLAT BEARPAW
D2432B: BENT BEARPAW

MATERIAL: UHMW BLACK PER SPEC CONTROL DRAWING D2689
1.00 THICK (MACHINE TO 0.950)

DESIGN KE		DRAWING BY KE		DARI AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED MM	APPROVED A	DRAWING NO. D2432		REV. F SHEET 1 OF 2	
DATE 98.05.12		TITLE BEARPAW		SCALE 1:6	
A	95.10.31	NEW ISSUE			
B	96.01.24	RE-DESIGN			
C	96.03.26	CHANGE BORE AND C'BORE DEPTH			
D	96.06.04	MOVE SLOT			
E	97.02.27	CHANGE C'BORE DEPTH, BORE RADIUS			
F	98.05.12	CHANGE C'BORE, ADD B AND F P/N			

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Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

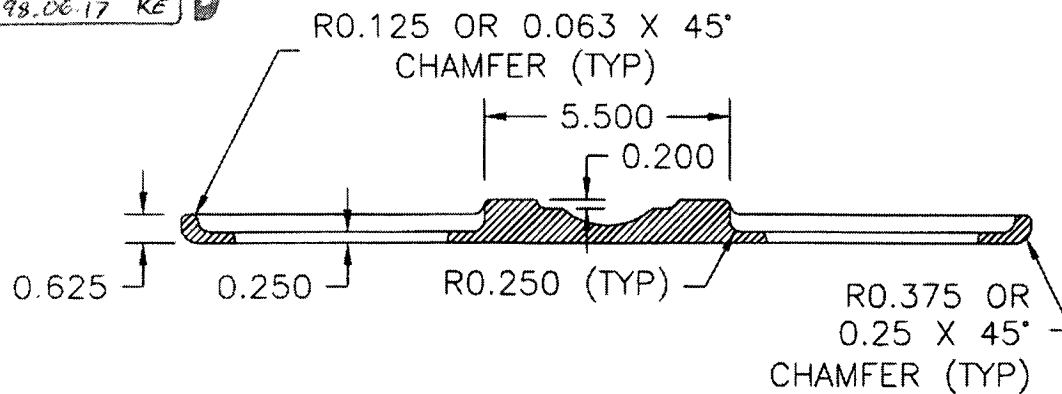
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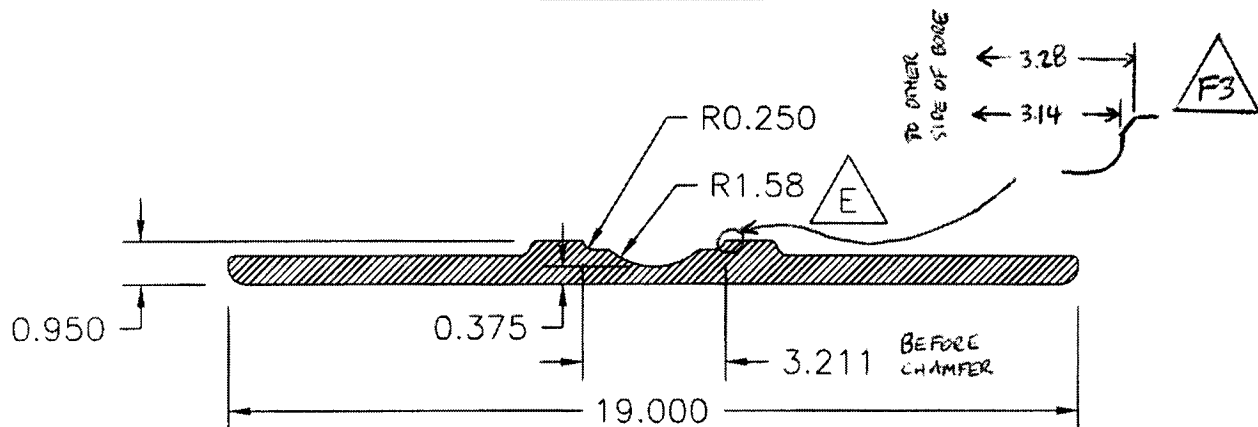


DESIGN <i>KE</i>	DRAWN BY <i>KE</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>MA</i>	APPROVED <i>MA</i>	DRAWING NO. D2432	REV. F SHEET 2 OF 2
DATE 98.05.12		TITLE BEARPAW	SCALE 1:4

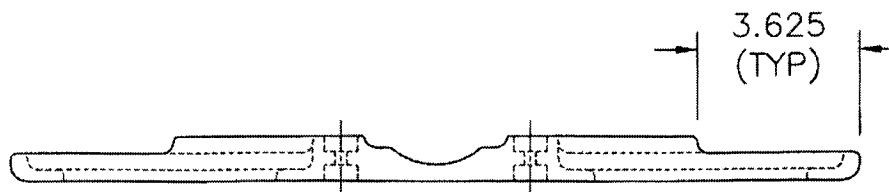
RELEASED
98.06.17 KE



SECTION A-A



SECTION B-B



SECTION C-C

24803

W/O:		WORK ORDER CHANGES					
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